



Dart Aerospace Ltd.
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Canada

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D3407-5

Job Sheet 181233



Part No: D3407-5

Job Qty: 20 ea

Part Name: Ring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IPP Rev:A New Issue 05-11-22 JLM IPP Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		8/31/18	0.00	0.00	Start Up Waterjet		18/07/28 DAS
100	Waterjet	20 pcs		8/31/18	0.03	1.83	Waterjet1		18/07/28 52 18/07/31
110	QC	20 pcs		8/31/18	0.00	0.00	QC2		18/07/28 9-89
115	Lathe Conv	20 pcs		8/31/18	0.00	1.32	Lathe Conv-1		DP 18-08-16
117	QC	20 pcs		8/31/18	0.00	0.00	QC2		DP 18-08-16
120	QC	20 pcs		8/31/18	0.00	0.00	QC8		mark 18/08/21
130	Packaging	20 pcs		8/31/18	0.00	0.00	Packaging3		DAS 21
140	QC21-SA	20 Ea		8/31/18	0.00	0.00	QC21		AUG 29 2018

Part Op 100 - 1-Cut as per Dwg D3407 Dwg Rev: E Prog Rev: E 2-Break edges on manual lathe Dwg D3407
Descriptions: (175rpm)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M174PH-H900B0.250X4.000	17-4 H900 SS Bar 0.250" X 4.000"	5.3200 ft (.266 ea)	90-Start up Operation	5055085

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M174PH-H900B0.250X4.000	5	0	0

M17-4-H900-B0.250x4.000 CX JUL 25 2018

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tow Ring	0.250inches $\pm$ 0.010	0.260 0.240		
2	Tow Ring	3.000inches $\pm$ 0.030	3.030 2.970		
3	Tow Ring	2.050inches + 0.012 - 0.001	2.062 2.049		
4	Tow Ring	0.750inches $\pm$ 0.030	0.780 0.720		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

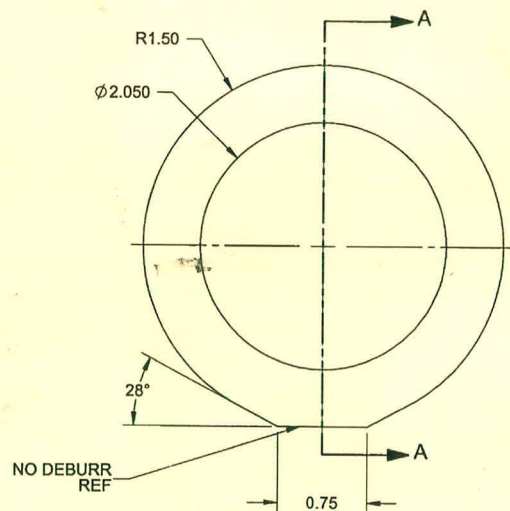
Work Order: _____ Part No. _____ NCR No. _____		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube</td><td>☐</td> <td>Cross tube</td><td>☐</td> <td>Water Jet</td><td>☐</td> <td>Engineering</td><td>☐</td> </tr> <tr> <td>Machining</td><td>☐</td> <td>Small Fab</td><td>☐</td> <td>Prod. Eng. Coord.</td><td>☐</td> <td>Quality</td><td>☐</td> </tr> <tr> <td>Forming</td><td>☐</td> <td>Finishing</td><td>☐</td> <td>Rec/Store/Packaging</td><td>☐</td> <td>Other</td><td>☐</td> </tr> <tr> <td>Assembly</td><td>☐</td> <td>Composite</td><td>☐</td> <td>Supplier</td><td>☐</td> <td></td><td></td> </tr> </table>				Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐	Forming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐	Assembly	☐	Composite	☐	Supplier	☐		
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Assembly	☐	Composite	☐	Supplier	☐																																
Date : _____		MRB (QSI042) Approval																																			
Dr _____		Completed By																																			
Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval																																			

DART AEROSPACE
 Container No: S097202
 Part: D3407-5
 Job No: 181233
 Serial No/Batch: S097202
 Revision: G
 Inspector: _____
 Exp Date: _____
 Instructions: Various STC's

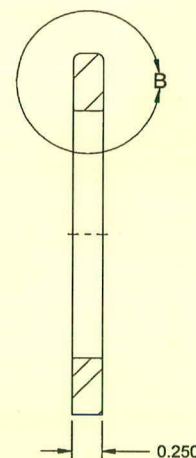
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Date: 07/29/16

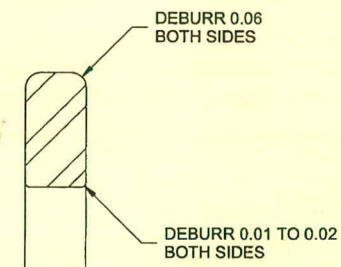
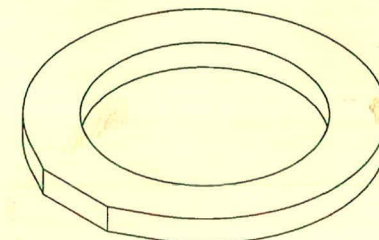
Root Cause			OTHER		
Environment	☐	No Re-verification	Pressure/Forced	☐	Power Loss/Surge
Design	☐	Operator	Bending	☐	Folio/Program
Doc/Data	☐	Offset/Setup	Centre Not Concentric	☐	Grain
Equip/Tooling	☐	Supplier	Cracks	☐	Weld
Handling/Pre	☐	Training	Crimp/Kink/Ripple/Wave	☐	Wrong Stock Pulled
Material	☐	Use for Testing	Cuffs	☐	Out of Sequence
Internal Transport	☐	Poor Information	Crushing	☐	Off-set
Tribal Knowledge	☐	Rushing	Heat Treat	☐	Mislabeled
LOA	☐	Product Improvement	Wave/Twist in Tube	☐	Fit/Function
Substation	☐	Process Improvement	Marks/Chatter	☐	Misaligned/off center
Past Expiry Date	☐	Manufacturing Process			
Misidentified	☐	Past Due	OTHER :		



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

NOTES:

- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643, H900 CONDITION
MINIMUM ULTIMATE TENSILE STRENGTH = 190 KSI
MINIMUM YIELD TENSILE STRENGTH = 170 KS
REF. DART SPEC M17-4-H900-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

RELEASED
2017-10-31

APPROVED

DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. G
MFG. APPR.	DD	D3407	SHEET 4 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	TOW RING	NTS
DATE	17.09.07	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

